



INTERNATIONAL APPLICATION PUBLISHED UNDER THE PATENT COOPERATION TREATY (PCT)

(51) International Patent Classification ⁷ : B65B 11/50, 47/02	A1	(11) International Publication Number: WO 00/55045 (43) International Publication Date: 21 September 2000 (21.09.00)
(21) International Application Number: PCT/EP00/01648 (22) International Filing Date: 29 February 2000 (29.02.00) (30) Priority Data: 9906176.4 17 March 1999 (17.03.99) GB (71) Applicant (for AE AU BB CA CY GB GD GH GM IE IL KE LC LK LS MN MW NZ SD SG SL SZ TT TZ UG ZA ZW only): UNILEVER PLC [GB/GB]; Unilever House, Blackfriars, London EC4P 4BQ (GB). (71) Applicant (for all designated States except AE AU BB CA CY GB GD GH GM IE IL IN KE LC LK LS MN MW NZ SD SG SL SZ TT TZ UG ZA ZW): UNILEVER NV [NL/NL]; Weena 455, NL-3013 AL Rotterdam (NL). (71) Applicant (for IN only): HINDUSTAN LEVER LIMITED [IN/IN]; Hindustan Lever House, 165/166 Backbay Reclamation, Mumbai 400 020, Maharashtra (IN). (72) Inventor: HARBOUR, Richard; Lever Brothers Ltd, P.O. Box 69, Port Sunlight, Wirral, Merseyside CH62 4ZD (GB).		(74) Agents: ELLIOTT, Peter, William et al.; Unilever PLC, Patent Department, Colworth House, Sharnbrook, Bedford, Bedfordshire MK44 1LQ (GB). (81) Designated States: AE, AL, AM, AT, AU, AZ, BA, BB, BG, BR, BY, CA, CH, CN, CR, CU, CZ, DE, DK, DM, EE, ES, FI, GB, GD, GE, GH, GM, HR, HU, ID, IL, IN, IS, JP, KE, KG, KP, KR, KZ, LC, LK, LR, LS, LT, LU, LV, MA, MD, MG, MK, MN, MW, MX, NO, NZ, PL, PT, RO, RU, SD, SE, SG, SI, SK, SL, TJ, TM, TR, TT, TZ, UA, UG, UZ, VN, YU, ZA, ZW, ARIPO patent (GH, GM, KE, LS, MW, SD, SL, SZ, TZ, UG, ZW), Eurasian patent (AM, AZ, BY, KG, KZ, MD, RU, TJ, TM), European patent (AT, BE, CH, CY, DE, DK, ES, FI, FR, GB, GR, IE, IT, LU, MC, NL, PT, SE), OAPI patent (BF, BJ, CF, CG, CI, CM, GA, GN, GW, ML, MR, NE, SN, TD, TG). Published <i>With international search report.</i>
(54) Title: PROCESS FOR PRODUCING A WATER SOLUBLE PACKAGE (57) Abstract <p>A process for producing a thermoformed package comprises the steps of placing a first sheet of film over a forming die having at least one cavity, heating the film to mould the film into the at least one cavity thereby forming at least one recess in the film, placing a composition in the at least one formed recess; and sealing a second sheet of film across the at least one formed recess to produce at least one closed package. The film is heated by a heating plate having at least one concave depression which in use overlies the at least one cavity, wherein the heating step involves the step of bringing the film into intimate contact with the or each depression.</p>		

FOR THE PURPOSES OF INFORMATION ONLY

Codes used to identify States party to the PCT on the front pages of pamphlets publishing international applications under the PCT.

AL	Albania	ES	Spain	LS	Lesotho	SI	Slovenia
AM	Armenia	FI	Finland	LT	Lithuania	SK	Slovakia
AT	Austria	FR	France	LU	Luxembourg	SN	Senegal
AU	Australia	GA	Gabon	LV	Latvia	SZ	Swaziland
AZ	Azerbaijan	GB	United Kingdom	MC	Monaco	TD	Chad
BA	Bosnia and Herzegovina	GE	Georgia	MD	Republic of Moldova	TG	Togo
BB	Barbados	GH	Ghana	MG	Madagascar	TJ	Tajikistan
BE	Belgium	GN	Guinea	MK	The former Yugoslav Republic of Macedonia	TM	Turkmenistan
BF	Burkina Faso	GR	Greece	ML	Mali	TR	Turkey
BG	Bulgaria	HU	Hungary	MN	Mongolia	TT	Trinidad and Tobago
BJ	Benin	IE	Ireland	MR	Mauritania	UA	Ukraine
BR	Brazil	IL	Israel	MW	Malawi	UG	Uganda
BY	Belarus	IS	Iceland	MX	Mexico	US	United States of America
CA	Canada	IT	Italy	NE	Niger	UZ	Uzbekistan
CF	Central African Republic	JP	Japan	NL	Netherlands	VN	Viet Nam
CG	Congo	KE	Kenya	NO	Norway	YU	Yugoslavia
CH	Switzerland	KG	Kyrgyzstan	NZ	New Zealand	ZW	Zimbabwe
CI	Côte d'Ivoire	KP	Democratic People's Republic of Korea	PL	Poland		
CM	Cameroon	KR	Republic of Korea	PT	Portugal		
CN	China	KZ	Kazakstan	RO	Romania		
CU	Cuba	LC	Saint Lucia	RU	Russian Federation		
CZ	Czech Republic	LI	Liechtenstein	SD	Sudan		
DE	Germany	LK	Sri Lanka	SE	Sweden		
DK	Denmark	LR	Liberia	SG	Singapore		
EE	Estonia						

- 1 -

PROCESS FOR PRODUCING A WATER SOLUBLE PACKAGE

Introduction

5 The invention relates to a process for producing a thermoformed package of the type comprising the steps of placing a first sheet of formable film over a forming die having a cavity, moulding the film into the cavity thereby forming a recess in the film, placing a composition in the
10 thus formed recess, and sealing a second sheet of film across the recess to close the package. In particular, the invention relates to such a process for producing a water-soluble package containing a detergent composition.

15 Detergent compositions for the machine washing of laundry are provided in many forms. Probably the most prevalent form of laundry detergent is washing powder or granules. A problem with the use of these forms of detergent is that the product needs to be dosed into the machine in such a way
20 that the detergent is quickly and thoroughly dissolved in the wash water of the machine without coming into contact with the laundry in a solid form. In this regard many dosing devices which overcome this problem have been proposed. One such device disclosed in European Patent Nos. 0 343 070 and
25 0 343 069 teaches the use of a flexible fabric sock which holds the particulate detergent in the machine, the fabric of the sock being permeable to water so as to allow water enter the sock and carry the detergent out of the sock through the fabric walls in the form of an aqueous solution.

30 More recently unit dose forms of detergent have been proposed in the form of compressed tablets of detergent powder. A problem encountered with the provision of detergent tablets is that the tablets need to be strong enough to withstand storage and transport, yet weak enough
35 to disintegrate and dissolve quickly in the washing machine.

- 2 -

A further problem is the need to prevent the tablets "posting" in the porthole and between the drums of conventional washing machines. More recently these problems have been overcome by the provision of detergent tablets having specific chemical disintegrants which allow quick disintegration of the tablets in the aqueous environment of a washing machine, and by the provision of loosely fitting net bags which aid tablet disintegration and prevent "posting". However, as many of the current detergent tablets contain bleach and other irritant substances, the problem of handling the tablets remains.

The provision of detergent compositions in water-soluble films has been known for some time. Most of the documents relating to this subject describe water soluble film envelopes formed using a vertical form-fill-seal (VFFS) route. A problem with envelopes produced using this VFFS method is that, due to the constraints of the process, the resultant envelopes have seals which incorporate defined weak points where the seals overlap at corners. This results in envelopes, which are easily corrupted as a result of impacts suffered during transport. In an attempt to overcome the problems associated with such VFFS envelopes, European Patent Application No. 0 608 910 describes thermoformed water soluble packages for pesticidal compositions of the above mentioned type, which packages include a seal which does not have any angular intersections with itself. While this specification does provide a partial solution to the problem of weak seals, the thermoforming of water-soluble films results in formed packages having many other weak points. Moreover, the packaging and transport of such packages subjects the formed packages to considerable impact forces.

- 3 -

It is an object of the invention to overcome at least some of the above problems

Statements of Invention

5

According to the invention, there is provided a process for producing a thermoformed package of the above mentioned type, the process being characterised in that the film is heated by a heating plate having at least one concave
10 depression which in use overlies the at least one cavity, wherein the heating step involves the step of bringing the film into intimate contact with the or each depression. The use of a heating plate having one or more concave depressions improves uniformity of the thermoformed film
15 which results in a package having more uniform thickness and therefore fewer weak spots.

In one embodiment of the invention, intimate contact between the film and the concave depression is achieved by exerting
20 a vacuum between the depression and the film. In this regard the depression may include a hole or holes through which the vacuum may be pulled. Alternatively, the heating plate may comprise a porous material. When a vacuum is exerted in this manner, the vacuum should ideally comprise a pressure of up
25 to 1 Bar, and preferably be less than 0.6 Bar, for example about 0.3 Bar. In an alternative embodiment of the invention, the film is forced into intimate contact with the concave depression by blowing air against it. Typically the pressure of the blown air will be less than 5 Bar,
30 preferably less than 3 Bar. The heating plate preferably has a temperature in the region of 100 to 135 degrees C, and ideally is approximately 120 to 130 degrees C. Although the time the film contacts the heating plate depends to a large extent on the type of film used and the temperature of the
35 heating plate, the time of contact between the film and the

- 4 -

plate should be in the region 0.1 to 5 seconds, preferably 0.5 to 1seconds, ideally approximately 700 milliseconds.

In a particularly preferred embodiment of the invention, the
5 at least one concave depression is circular. In such a case
it is preferable that the ratio of the diameter of the
depression to the ratio of the depth of the depression is
between 4:1 and 50:1, typically between 5:1 and 40:1,
suitably between 7:1 and 30:1, ideally between 8:1 and 20:1.
10 In a most preferable embodiment, the ratio is approximately
10:1. Thus in an embodiment of the invention which will be
described in further detail below, the concave depression is
circular having a diameter of approximately 50 mm and a
depth of about 5mm.

15 Ideally, the concave depression has a radiussed edge.
Preferably the depression has a base having a radius of
curvature, wherein the ratio of the radius of curvature of
the base to the radius of curvature of the edge is
20 preferably between 5:1 to 1:1, and most preferably is about
2:1. Typically, a single plate may have a plurality of
concave depressions which in most instances will correspond
to an equal number of cavities in the forming die.

25 In one embodiment of the invention the film is a water-
soluble film. Ideally the package contains a liquid, gel or
other type of fluent composition. Preferably, the liquid
comprises a detergent or any other type of active agent used
in the machine washing of laundry or dishes. In another
30 embodiment of the invention, the package contains bathing or
shower gel composition or any other type of personal care
composition.

The invention also relates to a heating plate for
35 thermoforming film, which plate comprises at least one

- 5 -

concave depression. The concave depressions may include any of the features described above including the features relating to the radii of curvature of the base and edge of the depression.

5

Detailed Description of the Invention

The invention will be more clearly understood from the following description of an embodiment thereof, given by way of example only, with reference to the accompanying drawings in which:-

10

Fig 1 is a sectional view illustration portions of a forming die and heating plate according to the process of the invention; and

15

Fig 2 is a detailed sectional view of a concave depression used according to the invention.

20 EXAMPLE

In this example a thermoforming process is described where a number of packages according to the invention are produced from a sheet of water soluble material, namely polyvinyl alcohol supplied under reference CC8534 by Chris Craft. In this regard recesses are formed in the sheet using a forming die having a plurality of cavities with dimensions corresponding generally to the dimensions of the packages to be produced. Further, a single heating plate is used for preheating the film before moulding the film into all the cavities. In the same way a single sealing plate is described.

25

30

A first sheet of polyvinyl alcohol film is drawn over a forming die so that the film is placed over the plurality of

35

- 6 -

- forming cavities in the die. Each cavity is generally dome shape having a round edge, the edges of the cavities further being radiussed to remove any sharp edges which might damage the film during the forming or sealing steps of the process.
- 5 Each cavity further includes a raised surrounding flange. In order to maximise package strength, the film is delivered to the forming die in a crease free form and with minimum tension.
- 10 In the forming step, and referring to Figs 1 and 2, the film is heated to 125 degrees C, for approximately 600 microseconds. A heating plate 1 is used to heat the film, which plate is positioned to superpose the forming die 2. The plate includes a plurality of concave depressions 3
- 15 (only one is shown) which correspond to the recesses 4 on the forming die 2. Each concave depression is generally circular having a diameter of approximately 50mm and a depth of about 5mm. An edge 5 of the depression 3 is radiussed as is the base 6, the radius of the base being about 50mm and
- 20 the radius of the edge being about 30 mm. During this preheating step, a vacuum is pulled through the pre-heating plate to ensure intimate contact between the film and the pre-heating plate 1, this intimate contact ensuring that the film is heated evenly and uniformly (the extent of the
- 25 vacuum is dependant on the thermoforming conditions and the type of film used, however in the present context a vacuum of less than 0.6 bar was found to be suitable) Non-uniform heating results in a formed package having weak spots. As an alternative, or in addition, to the vacuum, it is possible
- 30 to blow air against the film to force it into intimate contact with the preheating plate. In such cases the air should be blown at a pressure of less than 3 Bar.

- After the preheating step, the thermoforming film is moulded
- 35 into the cavities in the die by the application of a vacuum

- 7 -

through the walls of the cavities and by blowing air through the depression. This vacuum is maintained at least until the packages are sealed. Once the recesses are formed and held in position by the vacuum, the composition, in this case a liquid detergent is added to each of the recesses. A second sheet of polyvinyl alcohol film is then superposed on the first sheet covering the filled recesses and heat-sealed thereto using a heating plate. The heat sealing plate has a number of annular protrusions corresponding to the raised flanges on the forming die. However, the heat sealing plate could also be flat.

The heat sealing plate operates at a temperature of about 140 to 180 degrees centigrade, and contacts the films for 1 to 2 seconds and with a force of 8 to 30kg/cm², preferably 10 to 20kg/cm². The raised flanges surrounding each cavity ensure that the films are sealed together along the flange to form a continuous seal. The radiussed edge of each cavity is at least partly formed a by a resiliently deformable material, such as for example silicone rubber. This results in reduced force being applied at the inner edge of the sealing flange to avoid heat/pressure damage to the film.

Once sealed, the packages formed are separated from the web of sheet film using cutting means. At this stage it is possible to release the vacuum on the die, and eject the formed packages from the forming die. In this way the packages are formed, filled and sealed while nesting in the forming die. In addition they may be cut while in the forming die as well.

During the forming, filling and sealing steps of the process, the relative humidity of the atmosphere is controlled to ca. 50%. This is done to maintain the heat sealing characteristics of the film. When handling thinner

- 8 -

films it may be necessary to reduce the relative humidity to ensure that the films have a relatively low degree of plasticisation and as such tend to be stiffer resulting in easier handling. The actual specific RH of the atmosphere
5 needed will vary according to the temperature of the environment and the type of film used, however for temperatures in the region of 20 degrees C, the RH should be in the region of 30 to 50% depending on the thickness and elasticity of the film.

10

The invention is not limited to the embodiments hereinbefore described which may be varied in both construction, detail and process step without departing from the spirit of the invention.

15

- 9 -

CLAIMS

1. A process for producing a thermoformed package comprising
5 the steps of: -
- placing a first sheet of film over a forming die having
at least one cavity;
 - 10 - heating the film;
 - moulding the film into the at least one cavity thereby
forming at least one recess in the film;
 - 15 - placing a composition in the at least one formed recess;
and
 - sealing a second sheet of film across the at least one
formed recess to produce at least one closed package,
20
- the process being characterised in that the film is
heated by a heating plate having at least one concave
depression which in use overlies the at least one
cavity, wherein the heating step involves the step of
25 bringing the film into intimate contact with the or each
depression.
2. A process as claimed in claim 1 in which the concave
depression is generally circular.
- 30
3. A process as claimed in claims 1 or 2 in which a ratio
of a diameter of the depression to a depth of the
depression is between 4:1 and 50:1.

35

- 10 -

4. A process as claimed in claim 3 in which the ratio is approximately 10:1.
- 5 5. A process as claimed in claim 4 in which an edge of the depression is curved, chamfered or bevelled.
6. A process as claimed in claim 5 in which the curved edge has a radius of curvature.
- 10 7. A process as claimed in claim 6 in which a base of the depression has a radius of curvature, wherein a ratio of the radius of curvature of the base to the radius of curvature of the edge is between 5:1 and 1:1.
- 15 8. A process as claimed in claim 7 in which the ratio is about 2:1.
9. A process according to any one of claims 1 to 8, wherein the film is brought into intimate contact with
20 the depression by sucking or by blowing the film.
10. A package formed by a process as claimed in any of claims 1 to 9.

1/1

Fig.1.

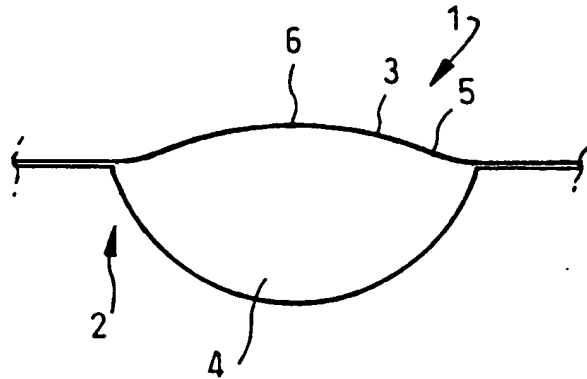
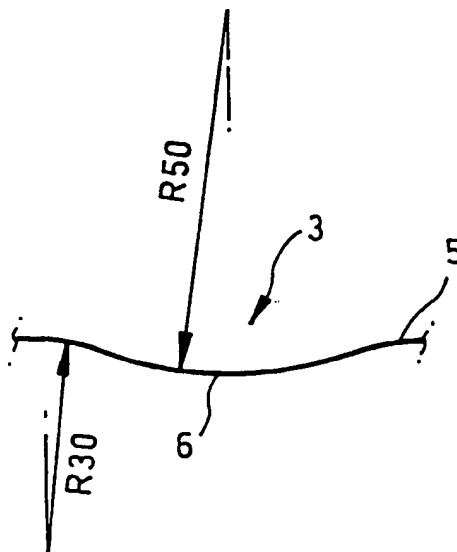


Fig.2.



INTERNATIONAL SEARCH REPORT

Internat Application No

PCT/EP 00/01648

A. CLASSIFICATION OF SUBJECT MATTER

IPC 7 B65B11/50 B65B47/02

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

IPC 7 B65B B29C

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practical, search terms used)

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category *	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
A	DE 93 03 456 U (MOSHEER) 29 April 1993 (1993-04-29) page 2, line 29 -page 4, line 20; figures 1-3	1,10
A	US 3 958 394 A (MAHAFFY) 25 May 1976 (1976-05-25) column 7, line 14 - line 42; figure 7	1
A	US 5 394 603 A (TETRA LAVAL) 7 March 1995 (1995-03-07) column 5, line 22 -column 7, line 37; figures 1-5	1



Further documents are listed in the continuation of box C.



Patent family members are listed in annex.

* Special categories of cited documents:

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier document but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art.

"&" document member of the same patent family

Date of the actual completion of the international search

26 May 2000

Date of mailing of the international search report

16/06/2000

Name and mailing address of the ISA

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040, Tx. 31 651 epo nl,
Fax: (+31-70) 340-3018

Authorized officer

Claeys, H

INTERNATIONAL SEARCH REPORT

Information on patent family members

International Application No

PCT/EP 00/01648

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
DE 9303456 U	29-04-1993	NONE	
US 3958394 A	25-05-1976	US RE29937 E CA 1002442 A DE 2301217 A GB 1398811 A JP 1113972 C JP 48079089 A JP 57005722 B	20-03-1979 28-12-1976 09-08-1973 25-06-1975 16-09-1982 23-10-1973 01-02-1982
US 5394603 A	07-03-1995	DE 4019632 A AT 141853 T AU 644173 B AU 7849191 A CA 2044930 A,C CS 9101885 A DE 59108111 D DK 462481 T EP 0462481 A ES 2090176 T GR 3020905 T HU 211410 B JP 6344461 A RU 2047494 C US 5227177 A	02-01-1992 15-09-1996 02-12-1993 02-01-1992 21-12-1991 15-04-1992 02-10-1996 16-09-1996 27-12-1991 16-10-1996 30-11-1996 28-11-1995 20-12-1994 10-11-1995 13-07-1993